

# Work Order ID 76060

**\*76060\***

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Friday, November 04, 2011 10:11:20 AM

Item ID: DSK078 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: D2893-1 TURNING DETAIL  
 Start Date: 11/4/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 11/11/2011 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan:                      Date: 11/11/04 Tooling:                      Date:                      Run Start **\*NR1\***  
 QC:                      Date:                      SPC (Y/N):                      Date:                      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSK078	Rev A

100		0.00							
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**\*100\***  
 Doosan  
 Doosan Lathe

Memo  
 Turn blank as per Folio FA081  
 (4TH AXIS PLUG DT8492)

10 10 11 18

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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**\*110\***  
 QC  
 Quality Control

Memo

10 10 11 18

120	QC8- Inspect parts - second check	0.00							
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**\*120\***  
 QC  
 Quality Control

Memo

10 11/11/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DSK 078 PAR #: \_\_\_\_\_ Fault Category: Machin NCR: Yes No DQA: g Date: 11/11/24  
 Resolution: use as in Disposition: use as in QA: N/C Closed: cf Date: 11/11/24

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/22	100	100 ridge is tapered. origin moved after finishing tool was passed. R.C.L.O.A.	CP 11/11/22 CS/012	Acceptable	11/11/22	8 w/11/22	CP 11/11/22 CS/012	8 11/11/22
		C Fai + Dig is clean Golio is correct						

NOTE: Date & initial all entries

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Friday, November 04, 2011 10:11:20 AM

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: <u>DSK078</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

ME  
11-11-23

# Picklist Print

Friday, November 04, 2011 10:11:24 AM

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Work Order ID: 76060

**\*76060\***

Parent Item: DSK078

**\*DSK078\***

Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 11/4/2011

Required Date: 11/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-005

Manufactured No

Each

4.0000

10

**\*D6104-005\***

**\*\***

Round Billet, 17-4

*SD 11/11/11*

Location

Loc Qty

Loc Code

MAT

3

70254

3

MAT047

1

71179

1

*B 76308*

*10*

DART AEROSPACE LTD		Work Order:	76060
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.711	2.712	2.712	2.712	2.712
B	4.946	4.966		4.959	4.959	4.959	4.959	4.959
C	3.064	3.084		3.074	3.074	3.074	3.074	3.074
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.934	2.954		2.945	2.945	2.945	2.944	2.944
G	2.166	2.186		2.179	2.179	2.179	2.179	2.179
H	3.890	3.910		3.900	3.900	3.900	3.899	3.900
I	0.914	0.934		.927	.927	.927	.927	.927
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129		.115	.115	.115	.115	.115
L								
M								
N								
O								
P								

Measured by: *[Signature]* Date: 6/5/18

Audited by: *[Signature]* Date: 6/10/23

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	76060
<b>Description:</b> Turning Detail for D2893-1		<b>Part Number:</b>	DSK078
<b>Inspection Dwg:</b> DSK078	<b>Rev:</b> A	<b>Page 1 of 1</b>	

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Lathe Section								
A	2.707	2.712		2.712	2.712	2.712	2.712	2.712
B	4.946	4.966		4.958	4.958	4.958	4.958	4.958
C	3.064	3.084		3.074	3.074	3.074	3.074	3.074
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.934	2.954		2.944	2.944	2.944	2.944	2.944
G	2.166	2.186		2.175	2.175	2.175	2.175	2.175
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.927	.927	.927	.927	.927
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129		.115	.115	.115	.115	.115
L								
M								
N								
O								
P								

**Measured by:** SA **Date:** 11/11/18

**Audited by:** SMK **Date:** 11/11/23

**Prototype Approval:** **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

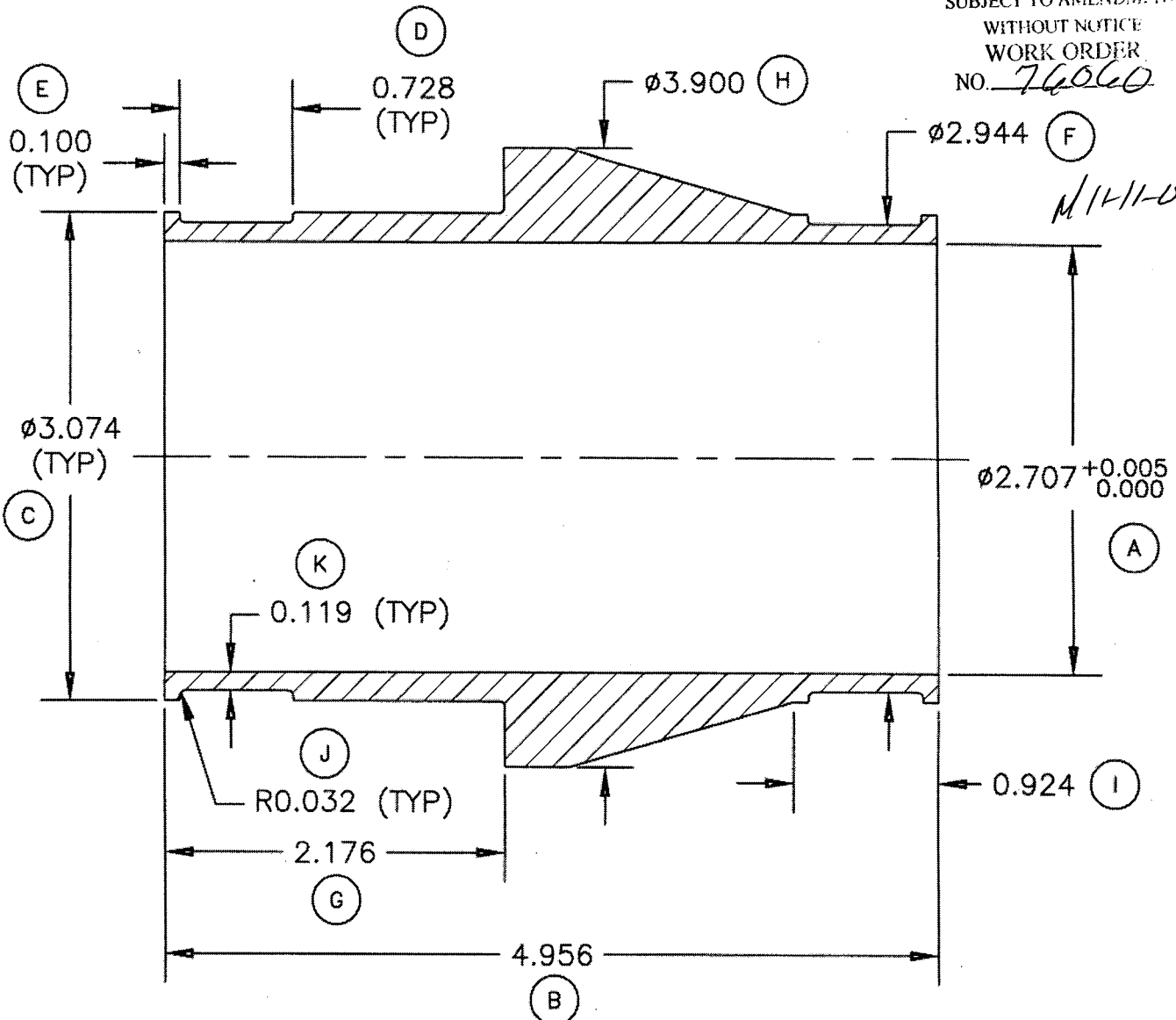


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
#03.07.01

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RETURN TO  
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WORK ORDER  
NO. 76060

M/1411-04



D2893-1 TURNING DETAIL

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